

Work Order ID 54571

December 14, 2009 10:42:19 AM



Page 1

Item ID:	D3136-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Window Assembly					
Start Date:	14/12/2009	Start Qty: 8.00		Cost Item ID:		
Required Date:	21/12/2009	Req'd Qty: 8.00		Customer:		
Reference:						
Approvals:	Process Plan: <i>RF</i>	Date: <i>09-12-14</i>	Tooling:		Date:	
	QC:	Date:	SPC (Y/N):		Date:	
				Run	Start	
					Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3136	Rev E								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet									
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

18 9-12-15

9

18 9-12-15

27 50912/15

KS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54571

December 14, 2009 10:42:20 AM



Page 2

Item ID: D3136-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Window Assembly

Start Date: 14/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-Thermoform as per Dwg D3136 and Folio FTA006 □ Dwg
Rev. E □ Folio Rev. C □ 2- Engrave Part # and
Batch #, and affix labels □ (D3108-9)

09/12/17
X9

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

09/12/17
X9

150

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

09/12/17
X9

W/O:		WORK ORDER CHANGES					
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Setup Start



Revision ID:

Stop



Item Name: Window Assembly

Start Date: 14/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



Thermoform

HAND FINISHING THERMOFORMING

0.00

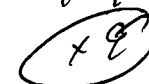
Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches as required

Li 09/12/12



170



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

27 809/12/16



180



Packaging

Identify as per dwg & Stock Location: 215

0.00

Memo

0.00

Packaging

C 09/12/12 369

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Setup Start



Revision ID:

Stop



Item Name: Window Assembly

Start Date: 14/12/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/09 *AG*

C209112123

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

December 14, 2009 10:42:23 AM

Page 1
1

Work Order ID: 54571



Parent Item: D3136-041



Parent Item Name: Window Assembly

Start Date: 14/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining # Qty To Pick	Qty Issued	Date Issued	Status
D3108-9 		Manufactured	No			100	Each	780.0000	16.0000			
Decal												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

780

34554

292

46546

488

22 AL 09/12/17

MACRLICS.125

Purchased

No

170

sf

229.6270

35.7895

40.26



B9125

1/8" Polycast II Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

229.627

110115

4

110633

17.2295

111711

67.7447

112888

0.7828

113204

139.87

13204

⑨

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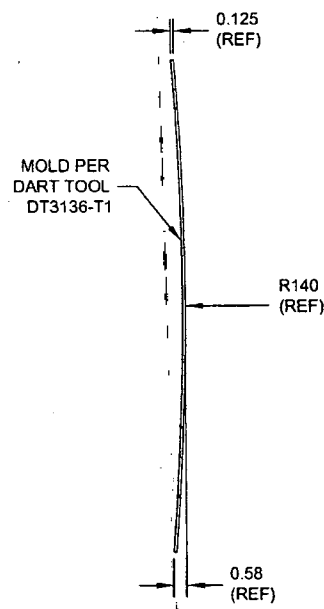
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BP 09-12-14

RELEASE
07.09.22

NOTES:

- | | | | |
|------------|--------------------------------|--|--------------|
| E | REMOVE TRIM NOTE | DC | 07.09.10 |
| D | UPDATED MATERIAL NOTES | RF | 05.12.01 |
| C | ADDED FORMING & ENGRAVING SPEC | KJ | 04.05.05 |
| B | ADDED D3136-3 AND D3136-043 | RF | 04.01.21 |
| A | NEW ISSUE | DS | 02.04.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>4</i> | DART AEROSPACE LTD | |
| DRAWN | <i>DC</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>RF</i> | DRAWING NO. | REV. E |
| MFG. APPR. | <i>RF</i> | D3136 | SHEET 1 OF 2 |
| APPROVED | <i>41</i> | TITLE | SCALE |
| DE APPR. | <i>41</i> | WINDOW ASSEMBLY | 1: |
| DATE | 07.09.10 | COPYRIGHT © 2002 BY DART AEROSPACE LTD
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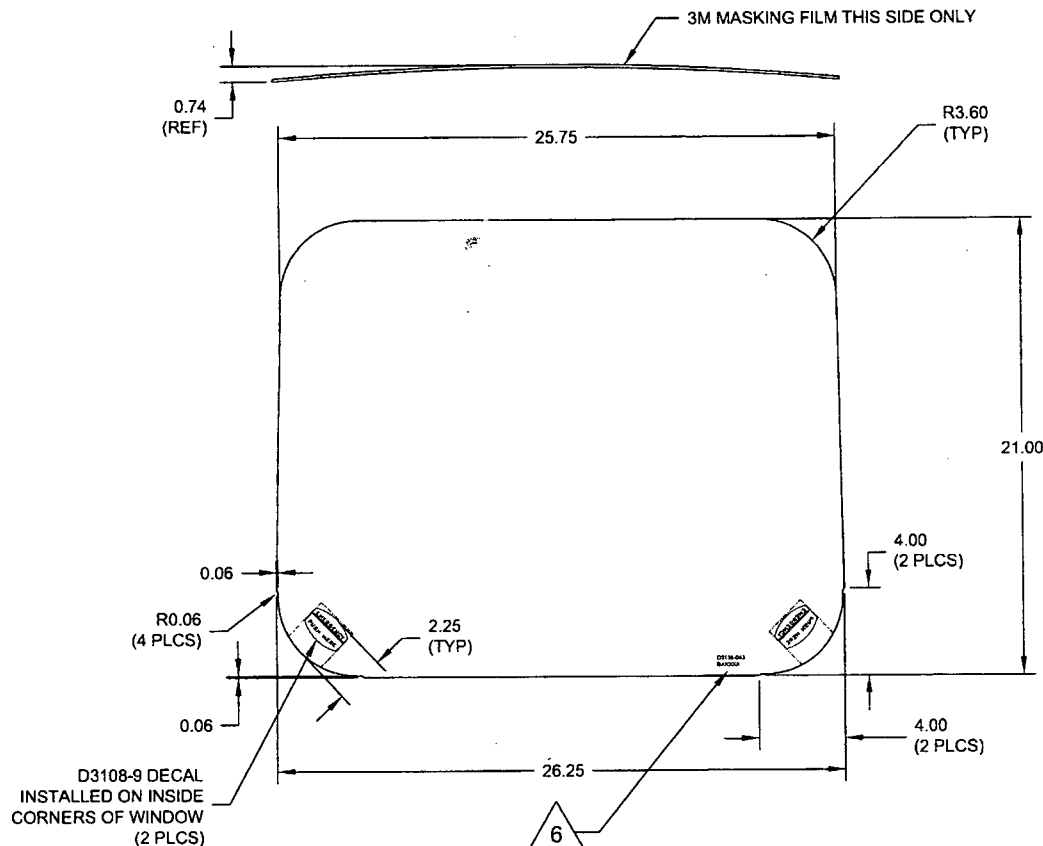
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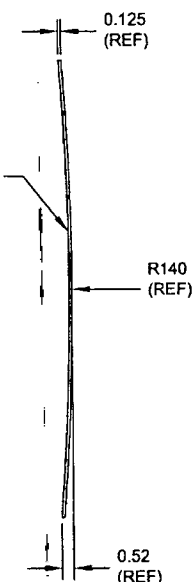
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MOLD PER
DART TOOL
DT3136-T1



SHOW COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54571

RELEASED
07.09.22

D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
(INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3136	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW ASSEMBLY	1:6
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